

Work Order ID 82723

82723

Page 1

Thursday, April 05, 2012 12:57:57 PM

Item ID: D135-751-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube Installation

Start Date: 4/5/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date: 12-04-5 Tooling:

Date:

Stop

NR2

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

1000

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

0.00

0.00

Handwritten: MJS 12-5-1

Handwritten: 5 12/65/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Cut Aft end as per dwg D3507 ✓

2-Deburr ends ✓

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 ✓

4-Locate DT8870 & Drill Ground wire hole on top of Tube. ✓

6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES**** ✓

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. ✓

8-Open six rear wearplate holes using DT8892. Open holes to 0.297" ✓

9-Open Aft & Fwd Cap holes using .208" drill. ✓

10-Bore out aft end of tube as per Dwg D3507 & Detail "B". ✓

11-Open ground wire hole .297" section E-E ✓

12- Section G-G holes must be laid out manually, open to #30. ✓

13-Deburr holes. ✓

- 12-04-17

- sm 12-04-19
- 12-04-17

W/O:		WORK ORDER CHANGES					
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NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

5/26/18

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

2/6/12-4-18

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DP 12-4-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00

170

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex

Batch: 12/22/1

Exp Date: 13/01/14

start time: 12/07/18

end time: 12-04-20

4.010

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD

Batch: m 120/64

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using D18871A&B

8-Deburr Rivet holes.

DC 12/04/18

DC 12/04/18

BE 12/04/20

CC 12-4-23 / DC 12/04/23

CC 12-4-24
12/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC10- Inspect visual per QSI004- ground welds	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Rivet D3506-1/-3 as per Dwg D3507.								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

1 X 0 12.04.24

1 0 12.4.24

5/24/24

Dart Aerospace Ltd

W/O: 82723		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Scrap Rivet only # 6.24					

Part No: D135-751-011 PAR #: _____ Fault Category: landing gear / scrap NCR: Yes No DQA: OK Date: 12/05/04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/5/7

NCR: 1243914		WORK ORDER NON-CONFORMANCE (NCR) # 1185289 6.24 rivet only						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/4/24	# 190	While Shaving Rivet the Shaver slipped in employee's hand. Re operator error	S 12/4/24	Scrap + Dashy Qty of D306-B Rivets B <u>74733</u> Qty of 1	CC 12-4-24	DD 12-4-24	S 12/4/24 25002	S 12/4/24

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NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Pressure Wash per QS1005 4.3

0.00

210

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QS1 005 section 4.1.2.1 do not acid etch.

UG 12-4-25

220

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

220

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
3200F
2:15

IX M-L 12/04/25

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

IX d M-L 12/04/25

M 12/11/34

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

0.00

260

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

✓ 1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

✓ 1- Inspect for Foreign objects

✓ 2- Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M1121221
Exp Date: 13/01

✓ 3- Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Screws where indicated on Dwg (Note #6)

✓ A/R 241 Sika Flex Batch: M1121221
Exp Date: 13/01

✓ 4- assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M1110348

✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: M1120859

ix d M 12/04/12

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Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300		0.00							
300	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: _____								
	PPP Rev: <u>B</u>								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

12/5/11

12-05-01

12-05-01

12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, April 05, 2012 12:58:01 PM

Page 1

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82723

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

Each

318.0000

38

AI S7-1032-130 ✕

**

1120837 (x38) H110120

Insert

ALS4-1032-130

Location

Loc Qty

Loc Code

ST280

165

117717

27

118966

22

119775

116

ST282

153

119530

73

120181

80

D3507-1-BENT

Manufactured

No

120

Each

7.0000

1

D3507-1-BENT

**

120413

Skidtube Assembly EC135

Location

Loc Qty

Loc Code

LG

7

75264

2

75265

2

77441

1

77443

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each 21.0000 2 2

D3504-1

**

Crossbolt Spacer

BE 12/04/20
B 82725 * 2

Location	Loc Qty	Loc Code
LG001	21	
53742	2	
75240	19	

D3504-3 Manufactured No

170 Each 11.0000 1 1

D3504-3

**

Crossbolt Spacer

BE 12/04/20
B 82726 * 1

Location	Loc Qty	Loc Code
LG001	11	
53743	11	

D3504-5 Manufactured No

170 Each 15.0000 2 2

D3504-5

**

Crossbolt Spacer

BE 12/04/20
B 76239

Location	Loc Qty	Loc Code
LG001	15	
76239	15	

D3505-1 Manufactured No

170 Each 3.0000 1 1

D3505-1

**

Web

DC 12/04/18

Location	Loc Qty	Loc Code
LG	2	
75256	2	
LG001	1	
75211	1	

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Shop Packet Print

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Dart Aerospace Ltd

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Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3506-1 Manufactured No

190 Each

44.0000

4

4

D3506-1

Doubler

**

CF/CC 12-4-24

Location

Loc Qty

Loc Code

ST051

44

74733

8

75090

36

(4/5)

D3506-3 Manufactured No

190 Each

57.0000

2

2

D3506-3

Doubler

**

CF/CC 12-4-24

Location

Loc Qty

Loc Code

ST051

57

51790

57

(2)

MS20601-AD4W3 Purchased No

190 Each

2,172.000

12

12

MS20601-AD4W3

Rivet

**

CF/CC 12-4-24

Location

Loc Qty

Loc Code

ST321

2172

114538

2172

(1/1)

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Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

260

Each

2,469.000

1

1

AI S4-1032-225

Handwritten: 4/12/12

Insert

Location

Loc Qty

Loc Code

ST281

2446

108696

146

110768

62

118386

55

118966

68

120671

115

121269

2000

ST282

23

120410

10

120451

13

Handwritten: X1

AN3C4A

Purchased

No

260

Each

3,020.000

31

31

AN3C4A

Handwritten: 4/12/12

BOLT

Location

Loc Qty

Loc Code

ST350

3020

120187

1982

120769

38

121205

1000

Handwritten: X31

W/O:		WORK ORDER CHANGES					
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Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No

260 Each 1,600.000 2 2

AN3C5A

Bolt

**

all 12/04/12

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1593

116419

28

117343

13

117764

7

117872

2

119749

23

120423

520

1210168

500

111210168

x2

121255

500

AN526C1032R10 Purchased No

260 Each 219.0000 2 2

AN526C1032R10

Screw

**

all 12/04/12

Location

Loc Qty

Loc Code

FP002

79

108062

79

x2

ST348

140

110049

40

114494

100

AN960C10L NAS1149C0332 Purchased No

260 Each 0.0000 33 33

AN960C10L

washer

**

all 12/04/12
11121255 = X18
11121509 = X15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 05, 2012 12:58:01 PM

Work Order ID: 82723

82723

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D2965 Manufactured No 260 Each 59.0000 1 1

D2965

Cap, 105 Skidtube

**

11 11/04/26

Location

Loc Qty

Loc Code

FP002

59

71371

9

80089

50

X1

D2965-3 Manufactured No 260 Each 8.0000 1 1

D2965-3

Cap

**

11 11/04/26

Location

Loc Qty

Loc Code

FP002

8

50560

1

75254

7

X1

D3492-1 Manufactured No 260 Each 30.0000 4 4

D3492-1

Plug

**

1383098 (x4) 11/04/26

Location

Loc Qty

Loc Code

FP002

30

69531

8

74444

2

76235

4

77037

16

D3492-3 Manufactured No 260 Each 1.0000 4 4

D3492-3

Plug

**

1383099 (x4) 11/04/26

Location

Loc Qty

Loc Code

FP-A

1

78600

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Thursday, April 05, 2012 12:58:01 PM

Work Order ID: 82723

82723

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-7 Manufactured No

260 Each

32.0000

2

2

D3492-7

Plug

**

u 12/04/20

Location

Loc Qty

Loc Code

FP002

32

71881

8

77222

24

xz

D3508-1 Manufactured No

260 Each

11.0000

1

1

D3508-1

Wearplate

**

u 12/04/20

Location

Loc Qty

Loc Code

FP002

11

72933

11

xl

D3508-3 Manufactured No

260 Each

12.0000

1

1

D3508-3

Wearplate

**

u 12/04/20

Location

Loc Qty

Loc Code

FP001

12

38527

1

81347

11

xl

D3508-5 Manufactured No

260 Each

15.0000

1

1

D3508-5

Wearplate

**

u 12/04/20

Location

Loc Qty

Loc Code

FP001

15

71688

6

72416

9

xl

Thursday, April 05, 2012 12:58:01 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Thursday, April 05, 2012 12:58:01 PM

Work Order ID: 82723

82723

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3508-7 Manufactured No

260

Each

12.0000

1

1

D3508-7

Wearplate

**

~~B72932~~ (x1) MU 12/04/12

B7C0265

Location

Loc Qty

Loc Code

FP001

12

76265

12

D3558-1 Manufactured No

260

Each

9.0000

1

1

D3558-1

Gasket

**

MU 12/04/12

Location

Loc Qty

Loc Code

FP002

9

50925

1

73561

8

D3558-3 Manufactured No

260

Each

13.0000

1

1

D3558-3

Gasket

**

MU 12/04/12

Location

Loc Qty

Loc Code

FP

12

82312

12

FP002

1

71651

1

D3558-5 Manufactured No

260

Each

11.0000

1

1

D3558-5

Gasket

**

MU 12/04/12

Location

Loc Qty

Loc Code

FP002

11

75255

11

Thursday, April 05, 2012 12:58:01 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 05, 2012 12:58:01 PM

Work Order ID: 82723

82723

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3558-7 Manufactured No

260 Each

9.0000

1

1

D3558-7

Gasket

**

u 4/10/12

Location

Loc Qty

Loc Code

FP002

9

75249

9

x1

NAS1611-007

Purchased No

260 Each

264.0000

2

2

NAS1611-007

O-RING

**

u 4/10/12

Location

Loc Qty

Loc Code

FP001

264

103697

264

x2

NAS1611-010

Purchased No

260 Each

259.0000

4

4

NAS1611-010

O-RING

**

u 4/10/12

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 05, 2012 12:58:01 PM

Page 10

Work Order ID: 82723

82723

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

260

Each

250.0000

4

4

NAS1611-013

O-RING

**

11/17/12 59 (44) 11/17/12 26

Location

Loc Qty

Loc Code

FP001

250

116582

5

117291

2

117887

53

119623

36

120910

4

121166

100

121259

50

X4

AN3C4A

Purchased

No

280

Each

3,020.000

8

8

AN3C4A

BOLT

**

8

187

Location

Loc Qty

Loc Code

ST350

3020

120187

1982

120769

38

121205

1000

8

AN960C10L

NAS1149C0332

Purchased

No

280

Each

0.0000

8

8

AN960C10L

washer

**

11/21/12 9

187

D3512-1

Manufactured

No

280

Each

5.0000

2

2

D3512-1

Wearplate

**

12/4/12

B81352

187

Location

Loc Qty

Loc Code

ST500

5

74735

5

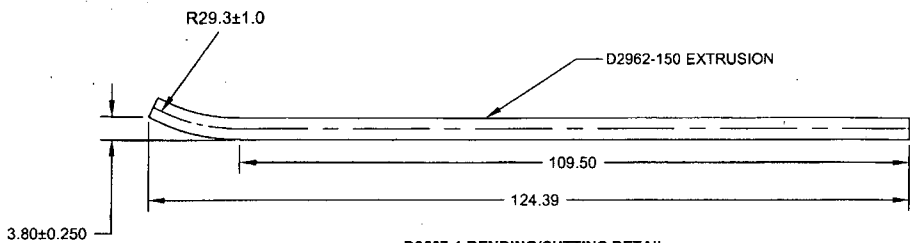
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

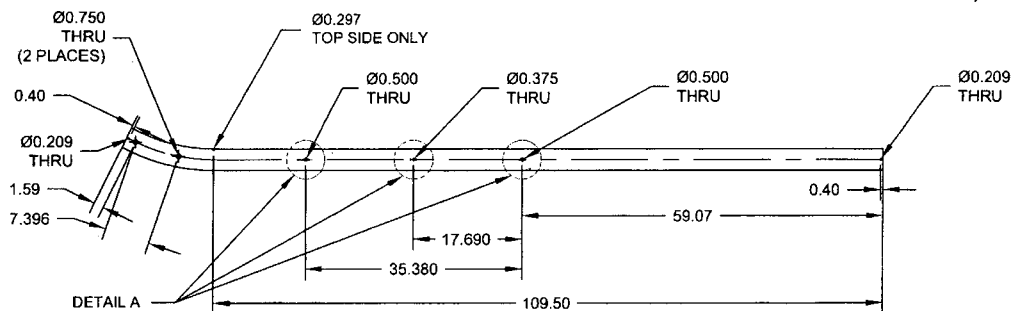
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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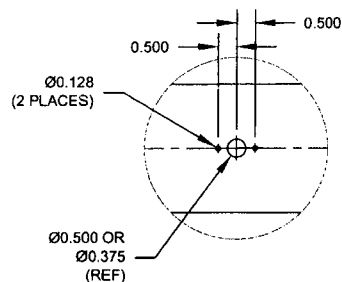
NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82723

1112-0413

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER
DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411/-291 ADHESIVE PER
DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>		
DRAWN	<i>JTC</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>CE</i>		
APPROVED	<i>PH</i>		
DE APPR.	<i>PH</i>		
DATE	07.09.19		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. **D3507** REV. **C**
SHEET 1 OF 2

TITLE **EC 135 SKIDTUBE** SCALE **NTS**

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RELEASED
07.11.14

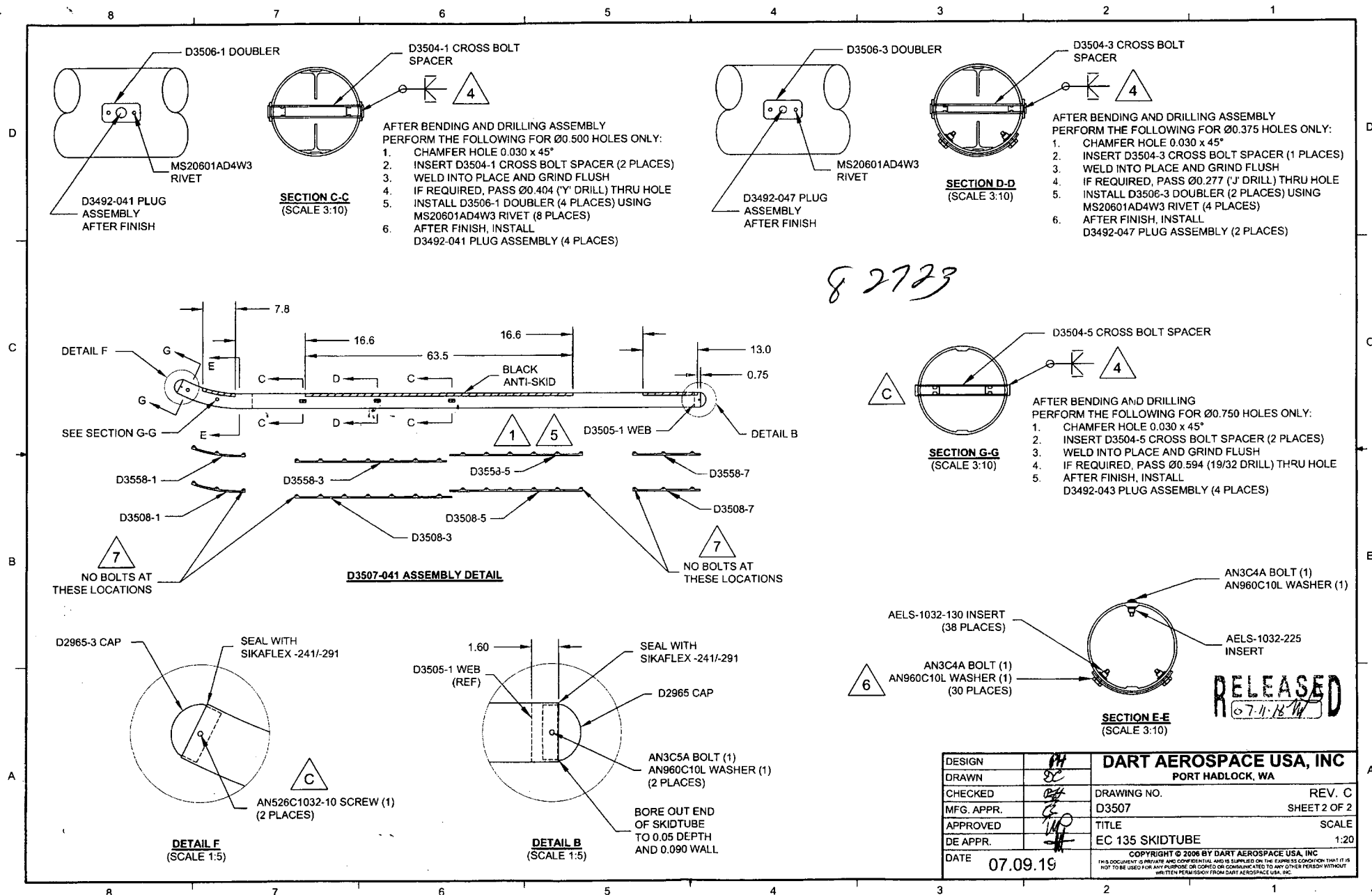
W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

NO. 247

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 66661
Part number: D135-751-011
Description: 135 SLID TWR
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☐] fail[]

Qualifier Pat Jones Date of Test Coupon 11/03/17
Welder Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld